

Work Order ID 61834

Tuesday, September 07, 2010 3:16:20 PM

Page 1

Item ID: D2054

Accept

Revision ID:

Item Name: Bushing

Start Date: 9/7/2010 Start Qty: 30.00

Required Date: 9/13/2010 Req'd Qty: 30.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2054

Rev B

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Machine as per folio FA□
Deburr

S.A. 10/10/05

30 0

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

S.A. 10/10/05

30 0

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

B.A. 10/10/05

30 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

Tuesday, September 07, 2010 3:16:20 PM

Accept

[illegible]**Setup Start**

Stop

Cust Item ID:

Start Date: 9/7/2010 **Start Qty:** 30.00

Required Date: 9/13/2010 **Req'd Qty:** 30.00

Customer:

Reference:

Run Start

[illegible]

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

[illegible]

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject Qty

Reject
Number

**Insp.
Stamp**

130

Identify as per dwg & Stock Location: 306

0.00

[illegible]

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Copy/17 (30)

10/10/07

MF
10-10-07

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, September 07, 2010 3:16:24 PM

Page 1

Work Order ID: 61834



Parent Item: D2054

Parent Item Name: Bushing

Start Date: 9/7/2010

Required Date: 9/13/2010

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP ☐ A1 03.01.21 Revise Dwg Rev B; added Black Teflon or Delring: Made on Cobra RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MDELNR1.000

Purchased

No

120

f

18.2300

0.0583

1.841053



Delrin Round Bar 1"



SD 10/10/05

Location

Loc Qty

Loc Code

MAT

12.94

— 114733

12.94

MAT050

5.29

108804

5.29

1.6 ft

W/O:		WORK ORDER CHANGES					
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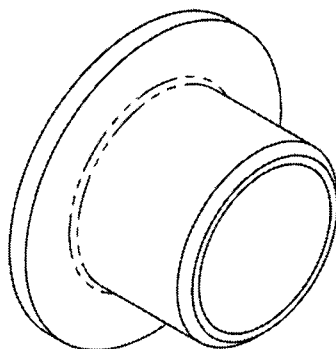
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN JB	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2054	REV. B SHEET 1 OF 1
DATE 01.12.20		TITLE BUSHING	SCALE 1:1
--	92.05.13	NEW ISSUE	
A	01.06.05	CHANGE TOL. ON ID.	
B	01.12.20	REDRAW; ADD DELRIN OPTION; ADD NOTES	

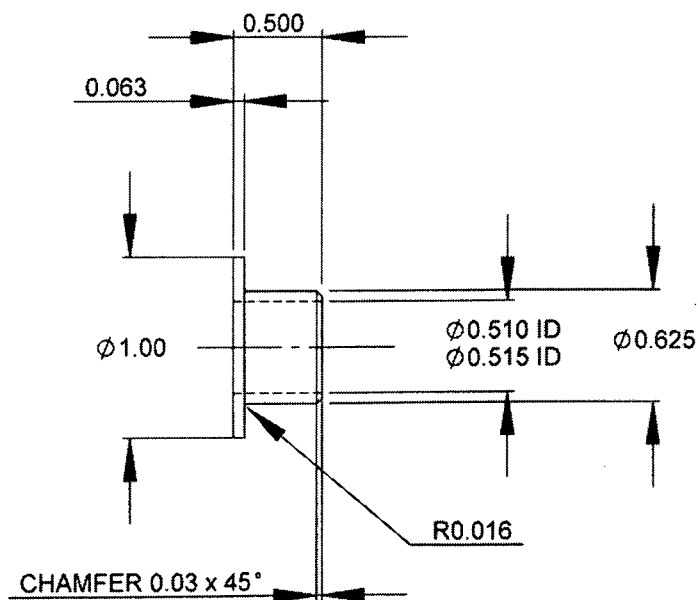
RELEASED
01.12.21



ISOMETRIC DETAIL (SCALE 2:1)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 01834

PSO-9-08



D2054 BUSHING

MATERIAL: BLACK TEFLON
or BLACK UHMW
or BLACK DELRIN

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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